

Work Order ID 76864

76864

Page 1

November-22-11 10:57:25 AM

Item ID: D2221 Accept ***N900040100*** Setup Start ***NS1***
 Revision ID: Stop ***NS2***
 Item Name: 350 Basket Base
 Start Date: 22/11/2011 Start Qty: 1.00 ***1*** Cust Item ID:
 Required Date: 30/11/2011 Req'd Qty: 1.00 ***1*** Customer:
 Reference:

Approvals: Process Plan: M.L.J Date: 11/11/12 Tooling: Date: Run Start ***NR1***
 QC: Date: SPC (Y/N): Date: Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
--------------------------------	--------------------------	----------------------	---------	--------	--------------	---------------	---------------	------------------	----------------

Draw Nbr	Revision Nbr
D2221	Rev H

100 0.00

100

Large Fab

Large Fab

Large Fab

Memo

0.00

1- assemble all ribs and both D2581 in DT9444 jig, weld as per dwg D2221
 2- remove basket from jig and weld D3442-1 shims and D2232-3 hinges as per dwg D2221
 3- tack weld mesh on basket as per dwg D2221
 A/R ER316 S.S. Rod Batch: 117884

PLEASE NOTE

IF MAKING -041A OR -043A :
 DRILL HOLES FOR GAS SPRING
 IN D3825-041 AS PER
 DSI 9473

Handwritten: 1x ~~0~~
 12.02.07

110

QC9- Inspect visual per QSI004- Fusion Welds 0.00

110

QC

Quality Control

Memo

0.00

Handwritten: BE
 12.02.07

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

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November-22-11 10:57:25 AM

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Accept

N900040100

Setup Start ***NS1***

Stop ***NS2***

Start Date: 22/11/2011 **Start Qty:** 1.00 ***1***

Cust Item ID:

Required Date: 30/11/2011 **Req'd Qty:** 1.00 *** 1 ***

Customer:

Reference:

Approvals: **Process Plan:** _____ **Date:** _____ **Tooling:** _____ **Date:** _____

Run Start *NR1*

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop *NR2*

**Insp.
Stamp**

0.00

120

0.00

QC

Memo

Quality Control

0.00

125

0.00

HandFinish

Memo

Hand Finishing

IX Ø M-L 12/02/17

W/O:		WORK ORDER CHANGES					
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130	White Gloss(Ref:4.3.5.2) per QSI005 4.3-Steel	0.00							
-----	---	------	--	--	--	--	--	--	--

130

Powdercoat

Powder Coating

Memo

1 - Plug holes prior to

1ST COAT:

START TIME: 11:45

OVEN TEMPERATURE: 400°F

FINISH TIME: 12:15

***** 2nd coat if necessary *****

2ND COAT:

START TIME: _____

OVEN TEMPERATURE: _____

FINISH TIME: _____

140	QC3- Inspect Part Finish	0.00							
-----	--------------------------	------	--	--	--	--	--	--	--

140

QC

Quality Control

Memo

0.00

IXP M/L 12/02/17

12 02 17 (1)

M119480

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DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

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Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
150	Identify as per dwg & Stock Location	0.00							
150									
Packaging	Memo	0.00							
Packaging									
160	QC21- Final Inspection - Work Order Release	0.00							
160									
QC	Memo	0.00							
Quality Control									

1 12/12/23

MLJ 12/02/24

12-02-24
D

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Picklist Print

November-22-11 10:57:29 AM

Page 1

Work Order ID: 76864

76864

Parent Item: D2221

D2221

Parent Item Name: 350 Basket Base

Start Date: 22/11/2011

Required Date: 30/11/2011

Start Qty: 1.00

Required Qty: 1.00

Comments: IPP Rev:J 05.09.02 Added D3442-1 KJ/JLM
 IPP Rev:K 08-08-29 revG as per dwg DD verified by:EC
 IPP Rev:L 08-09-24 plug holes prior to powder coat DD verified by:EC
 IPP Rev:M 08-12-02 revH as per dwg DD verified by:EC IPP Rev:N
 10.06.29 added pressure wash DD verf:EC

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
---------------------------------	------------------------	---------------	-------------	---------------------	------------------	-----------------	--------------------	----------------	-------------	--------------	---------------	----------------	--------

✓ D2221-1 *D2221-1* Rib		Manufactured	No			100	Each	16.0000	1	1			
-------------------------------	--	--------------	----	--	--	-----	------	---------	---	---	--	--	--

**

Pl 12.02.06

Location	Loc Qty	Loc Code
WA	16	
71372	4	
72297	12	

✓ D2221-5 *D2221-5* Rib		Manufactured	No			100	Each	12.0000	2	2			
-------------------------------	--	--------------	----	--	--	-----	------	---------	---	---	--	--	--

**

Pl 12.02.04

Location	Loc Qty	Loc Code
WA	10	
71218	10	
WA006	2	
67117	2	

✓ D2221-7 *D2221-7* Rib		Manufactured	No			100	Each	8.0000	1	1			
-------------------------------	--	--------------	----	--	--	-----	------	--------	---	---	--	--	--

**

Pl 12.02.06

Location	Loc Qty	Loc Code
WA	5	
71219	1	
73203	4	
WA006	3	
72731	3	

W/O:		WORK ORDER CHANGES					
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Page 2

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76864

Parent Item: D2221

D2221

Parent Item Name: 350 Basket Base

Start Date: 22/11/2011

Required Date: 30/11/2011

Start Qty: 1.00

Required Qty: 1.00

D2232-3

Manufactured No

100 Each

20.0000

2 2

✓ ***D2232-3***

Basket Hinge

**

Pl 12.02.06

Location

Loc Qty

Loc Code

WA

20

75581

20

B78903 → (2)

D2235-1

Manufactured No

100 Each

5.0000

2 2

✓ ***D2235-1***

Basket Rib

**

Pl 12.02.06

Location

Loc Qty

Loc Code

WA

1

73202

1

WA005

4

66895

4

B78636 → (2)

D2581

Manufactured No

100 Each

40.0000

2 2

✓ ***D2581***

Mounting Bracket

**

Pl 12.02.06

Location

Loc Qty

Loc Code

WA

40

69739

2

70766

2

73762

11

75280

25

377045 → (2)

D3442-1

Manufactured No

100 Each

19.0000

2 2

✓ ***D3442-1***

Shim

**

Pl 12.02.06

Location

Loc Qty

Loc Code

WA

19

71224

4

71783

15

(2)

November-22-11 10:57:29 AM

Shop Packet Print

Page 2

W/O:		WORK ORDER CHANGES					
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Page 3

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Parent Item: D2221

D2221

Parent Item Name: 350 Basket Base

Start Date: 22/11/2011

Required Date: 30/11/2011

Start Qty: 1.00

Required Qty: 1.00

✓ D3825-041

Manufactured No

100 Each

6.0000

2 2

D3825-041

Rib Assembly (Basket End)

**

Location

Loc Qty

Loc Code

WA006

6

72727

6

B77529 → ②

✓ D3826-041

Manufactured No

100 Each

10.0000

2 2

D3826-041

Rib / Gusset Assembly

**

Location

Loc Qty

Loc Code

WA

10

72728

4

73749

6

B77676 → ②

✓ D3827-041

Manufactured No

100 Each

9.0000

1 1

D3827-041

Rib Assembly (Inboard)

**

Location

Loc Qty

Loc Code

WA

9

72083

3

72729

6

B77546 → ①

✓ D3832-1

Manufactured No

100 Each

2.0000

1 1

D3832-1

Mesh (Base)

**

Location

Loc Qty

Loc Code

WA

2

72702

2

B73748 → ①

W/O:		WORK ORDER CHANGES					
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Page 4

Work Order ID: 76864

76864

Parent Item: D2221

D2221

Parent Item Name: 350 Basket Base

Start Date: 22/11/2011

Required Date: 30/11/2011

Start Qty: 1.00

Required Qty: 1.00

D3833-1

Manufactured No

100

Each

12.0000

2

2

D3833-1

Mesh (Base End Face)

**

Pl 12.00.06

Location

Loc Qty

Loc Code

WA

12

70470

6

71834

1

72866

5

B77521 → (2)

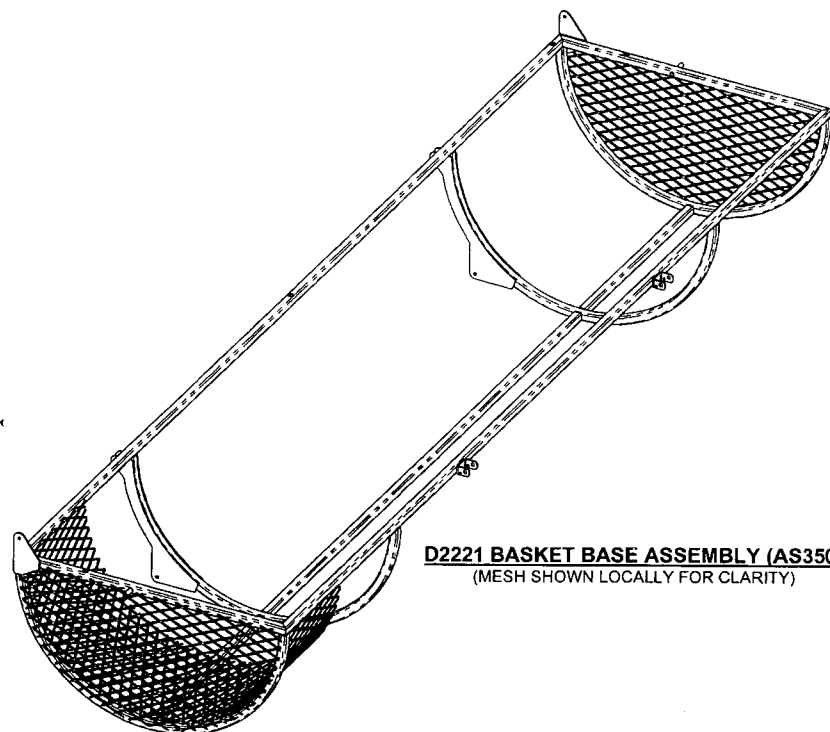
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D2221 BASKET BASE ASSEMBLY (AS350)
(MESH SHOWN LOCALLY FOR CLARITY)

STOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 76864 M.C.J

ITEM	QTY	P/N	DESCRIPTION
1	X	D2221	BASKET BASE ASSEMBLY (AS350)
2	1	D2221-1	RIB
3	2	D2221-5	RIB
4	1	D2221-7	RIB
5	2	D2232-3	BASKET HINGE
6	2	D2235-1	RIB
7	2	D2581	MOUNTING BRACKET
8	2	D3442-1	SHIM
9	2	D3825-041	RIB ASSY (BASKET END)
10	2	D3826-041	RIB/GUSSET ASSY
11	1	D3827-041	RIB ASSY (INBOARD)
12	2	D3833-1	MESH, BASE END FACE
13	1	D3832-1	MESH (BASE)

H	REVISED PARTS LIST AND ADDED "ITEM" COLUMN TO PARTS LIST (ZN D3-1); REVISED SECTIONS A-A, B-B AND C-C (ZN C6-3, C2-3 AND A6-3); REVISED DETAIL D (ZN B7-4); ADDED DETAIL E (ZN A6-4); ADDED SECTION F-F (ZN B2-4); ADDED DWG DETAILS FOR D2221-1/-5/-7 (SHEET 5); TOL REVISED TO 2 DEC PLACES (ZN D8-3 AND ZN B4-3); D3825-041 REPLACES D2221-3/D2221-3; D3826-041 REPLACES D2235-1/D2235; D3827-041 REPLACES D2221-1 ON INBOARD SIDE; ADDED D3832-1 AND D3833-1. REASON: SATISFY "LEAN MANUFACTURING" PROGRAM.	MB	08.09.18
G	MATERIAL FOR -1, -3, -5 & -7 WAS 0.060 WALL. TOLERANCE FOR 96.00 DIM WAS ± 0.01 AND 56.00 DIM WAS REF (ZN B5-2); 19.82 DIM WAS "HARD" DIMENSION IS NOW "REF" (ZN B4-2); NOTE 5 TRANSFERRED FROM SHT 1 TO SHT 2; SHT 2 MESH MATERIAL UPDATED; DRAWING TRANSFERRED TO "B" FORMAT	AJS	08.06.16
F	ADD SHIM UNDER HINGE; ADD HOLES FOR SPLIT LID BASKET	PH	05.06.07
E	CHANGE HINGE	CP	01.04.19
D	CHANGE LATCH	BW	96.06.21
C	SEPARATE BASKET AND LID	KH	95.11.21
REV	DESCRIPTION	BY	DATE
DESIGN	RW	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN			
CHECKED		DRAWING NO.	REV. H
MFG. APPR.		D2221	SHEET 1 OF 5
APPROVED		TITLE	SCALE
DE APPR.		BASKET BASE ASSEMBLY (350)	NTS
DATE	08.09.18	<small>COPYRIGHT © 1994 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR EXPOSED OR COMMUNICATED TO ANY OTHER PERSON, WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.</small>	

NOTES:

- 1) MATERIAL: N/A
- 2) FINISH: POWDER COAT GLOSS WHITE (4.3.5.2) PER DART QSI 005 4.3
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: N/A
- 8) WEIGHT: 42.00 lbs APPROX
- 9) MASK ALL HOLES PRIOR TO POWDER COATING

W/O:		WORK ORDER CHANGES					
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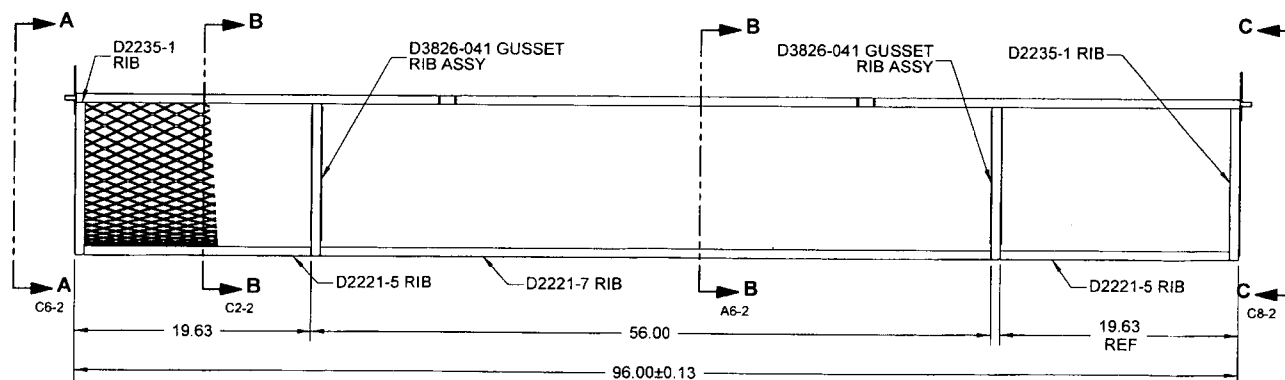
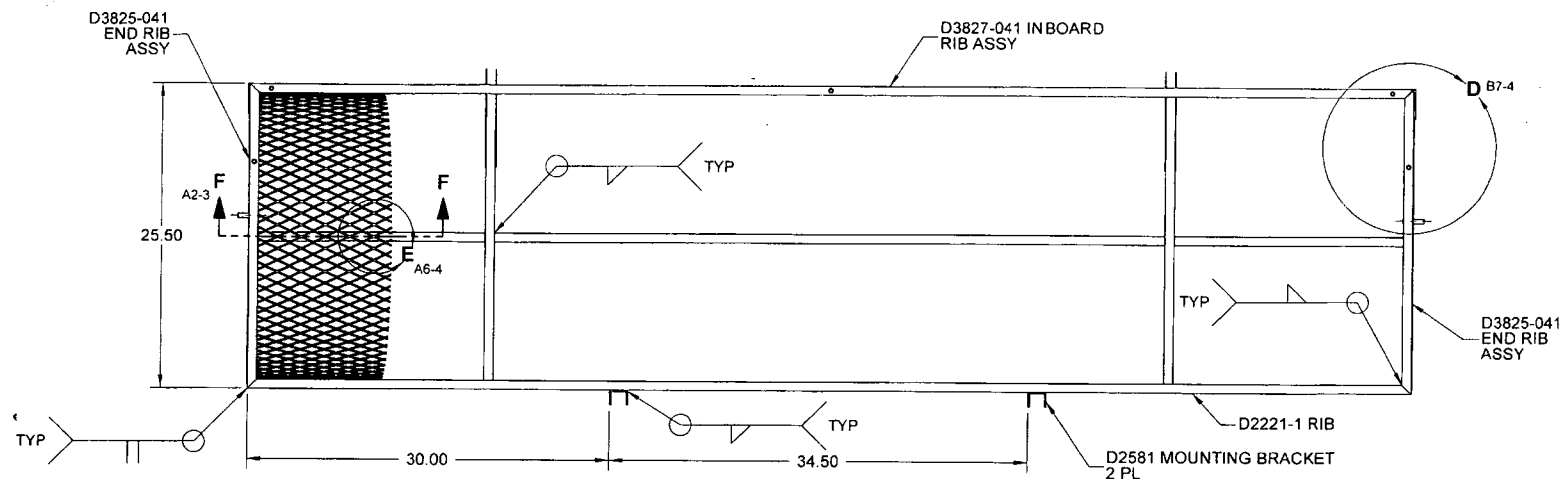
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D2221 BASKET BASE ASSEMBLY (350)
(MESH SHOWN LOCALLY FOR CLARITY)

RELEASED
06/11/18

DESIGN	B/W	DART AEROSPACE LTD	
DRAWN		HAWKESBURY, ONTARIO, CANADA	
CHECKED		DRAWING NO. D2221	REV. H
MFG. APPR.		SHEET 2 OF 5	
APPROVED		TITLE	SCALE
DE APPR.		BASKET BASE ASSEMBLY (350)	NTS
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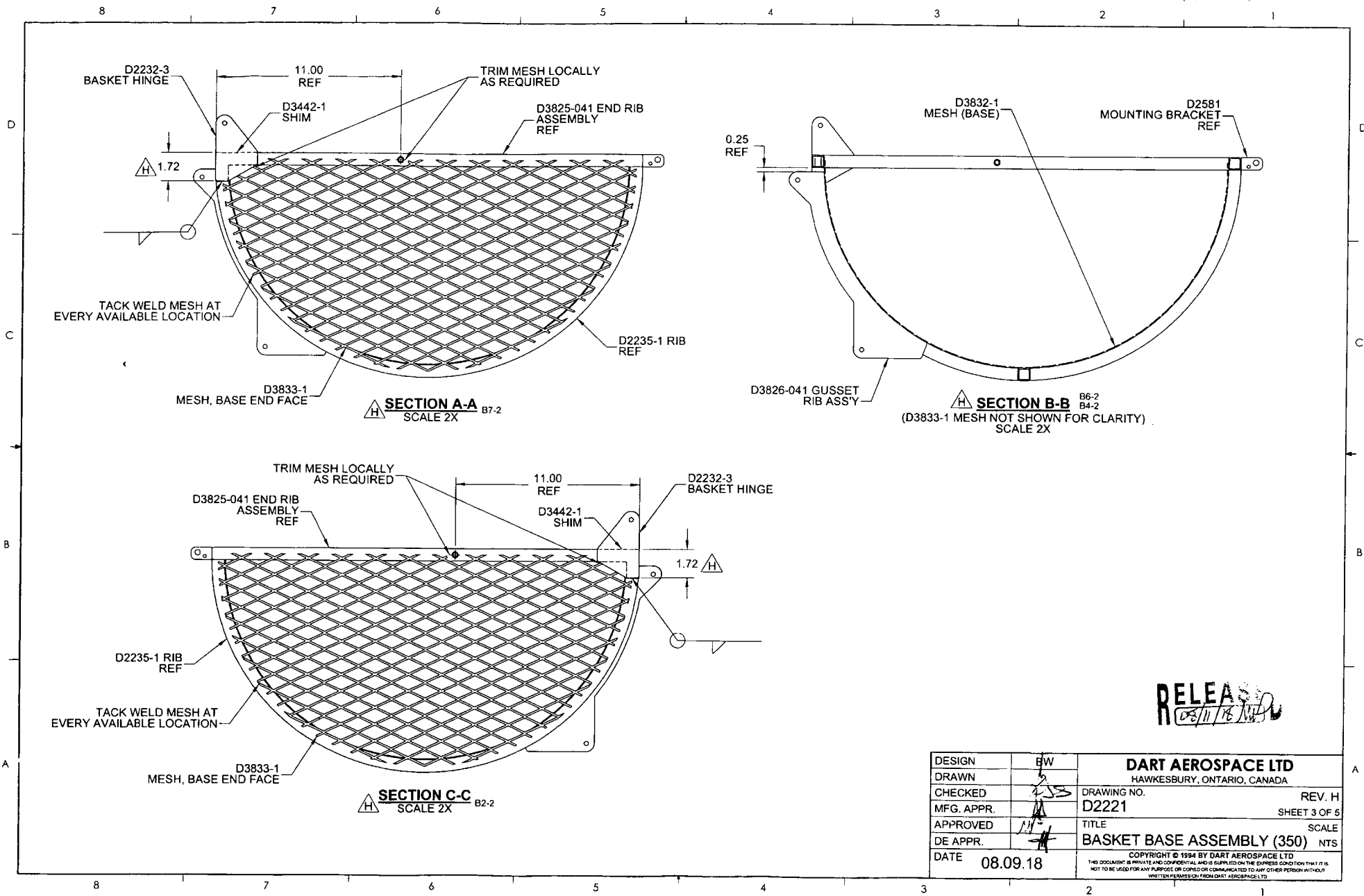
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NOTE: Date & initial all entries

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RELEASED
02/11/16

DESIGN	BW	DART AEROSPACE LTD	
DRAWN	233	HAWKESBURY, ONTARIO, CANADA	
CHECKED		DRAWING NO. D2221	REV. H
MFG. APPR.			SHEET 3 OF 6
APPROVED		TITLE	SCALE
DE APPR.		BASKET BASE ASSEMBLY (350)	NTS
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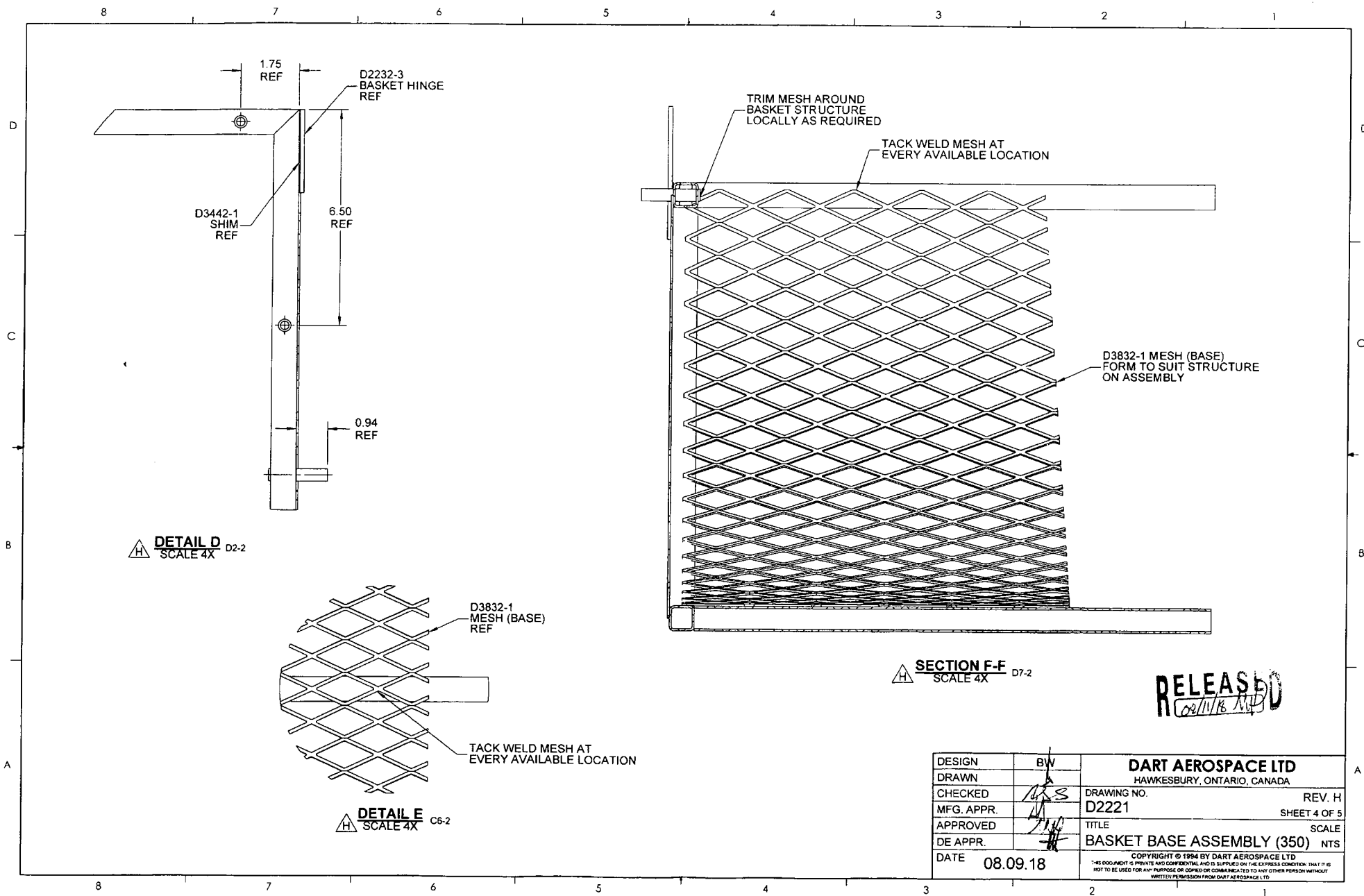
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DRAWN		HAWKESBURY, ONTARIO, CANADA	
CHECKED		DRAWING NO.	REV. H
MFG. APPR.		D2221	SHEET 4 OF 5
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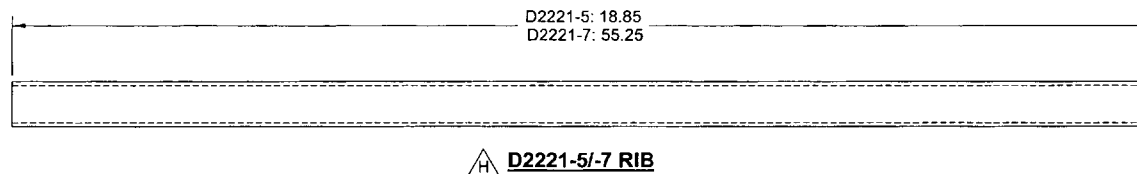
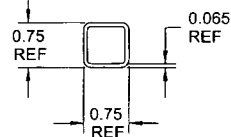
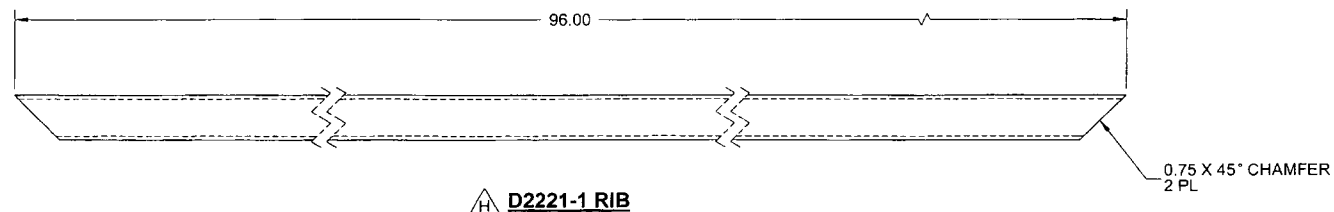
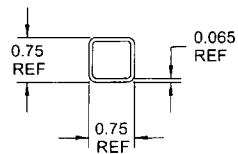
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RELEASED
08/11/18

- NOTES:**
- 1) MATERIAL: AISI 304/316 STAINLESS STEEL SQUARE TUBE, 0.75 X 0.75 X 0.065 WALL
REF. DART SPEC. M304TS0.750W0.065
 - 2) FINISH: NONE
 - 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
 - 4) UNITS: INCHES UNLESS OTHERWISE NOTED
 - 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
 - 6) IDENTIFICATION: N/A
 - 8) WEIGHT: D2221 -1 = 4.57 lbs; D2221-5 = 0.90 lbs; D2221-7 2.65 = lbs

DESIGN	BW	DART AEROSPACE LTD	
DRAWN		HAWKESBURY, ONTARIO, CANADA	
CHECKED		DRAWING NO.	REV. H
MFG. APPR.		D2221	SHEET 5 OF 5
APPROVED		TITLE	SCALE
DE APPR.		BASKET BASE ASSEMBLY (350)	NTS
DATE	08.09.18	<small>COPYRIGHT © 1994 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE, OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.</small>	

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries